



Dart Aerospace Ltd.
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K6A 1K7
Canada

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D3910-1

Job Sheet 193736



Part No: D3910-1

Job Qty: 2 pcs

Part Name: Crosstube Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/22/19

Job Tracking No:

Due Date: 5/6/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D3910 REV.E IPP REV:C 18.02.02 REMOVE FINISH DD VERF:JFS

Ship Via:

Bill of Materials

M.U. 009385

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	2 pcs	5/6/19	5/6/19	0.00	0.00	Purchasing - 1	5	
							Purchasing - 2	5	
							Purchasing - 3	5	
120	Packaging 2-1 - Receive - B4B	2 pcs	5/6/19	5/6/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		

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130	QC 6 3	2 pcs	5/6/19	0.00 0.00	Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					QC 6 - 9	68-6 29 SVD APR 30 2019
					QC 6 - 68	
180	Packaging 3-1 - Stock - B4B	2 pcs	5/6/19	0.00 0.00	QC 6 - 61	
					QC 6 - 40	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	68-6 29 SVD APR 30 2019
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					QC 21 - SA - 21	68-6 21 SVD APR 30 2019
					QC 21 - SA - 70	
QC 21 - SA - 53						

Part Op 110 - ISSUE PO TO METEC, NOTE ALODINE AND PAINT AS PER QSI 005

Descriptions: 120 - (Receive & Inspect for Damage & Mat'l Certs) Ensure C of C is attach

130 - (QC6- All purchased or subcontracted products)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

ST 503

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2423	Lug Extrusion	.2600 ft (.13 ea)	110-Purchasing	
D3910-1P	Crosstube Lug	2 pcs (1 ea)	110-Purchasing	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D2423	0	420	0
	D3910-1P	2	0	0

Part Specifications

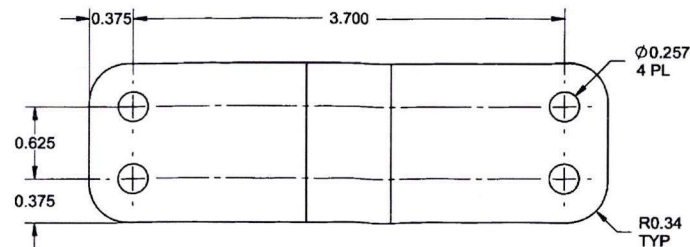
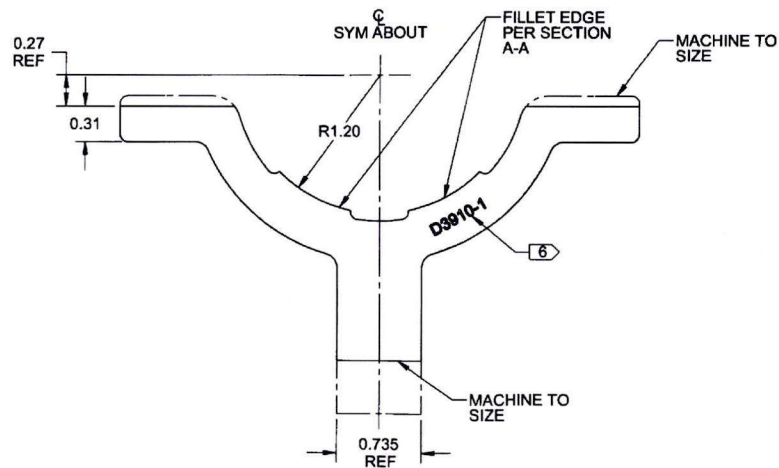
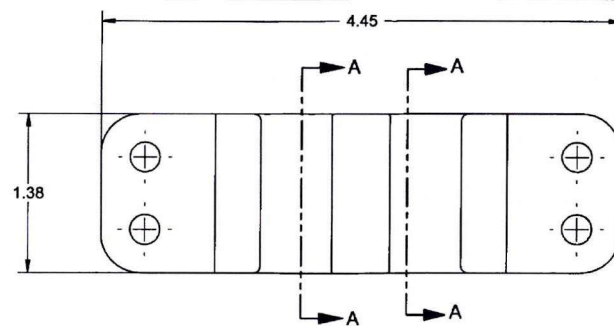
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crosstube Lug	4.450Inches ± 0.030	4.480 4.420		
2	Crosstube Lug	1.380Inches ± 0.030	1.410 1.350		
3	Crosstube Lug	0.270Inches ± 0.030	0.300 0.240	reference	
4	Crosstube Lug	0.310Inches ± 0.030	0.340 0.280		
5	Crosstube Lug	0.735Inches ± 0.010	0.745 0.725	reference	
6	Crosstube Lug	2.200Inches ± 0.030	2.230 2.170		
7	Crosstube Lug	0.375Inches ± 0.010	0.385 0.365		
8	Crosstube Lug	0.191Inches + 0.005 - 0.001	0.196 0.190	Diameter	
9	Crosstube Lug	0.380Inches ± 0.030	0.410 0.350	Radius	
10	Crosstube Lug	0.380Inches ± 0.030	0.410 0.350		
11	Crosstube Lug	0.625Inches ± 0.010	0.635 0.615		
12	Crosstube Lug	0.375Inches ± 0.010	0.385 0.365		
13	Crosstube Lug	3.700Inches ± 0.010	3.710 3.690		
14	Crosstube Lug	0.625Inches ± 0.010	0.635 0.615		
15	Crosstube Lug	0.375Inches ± 0.010	0.385 0.365		
16	Crosstube Lug	0.340Inches ± 0.030	0.370 0.310	Radius	

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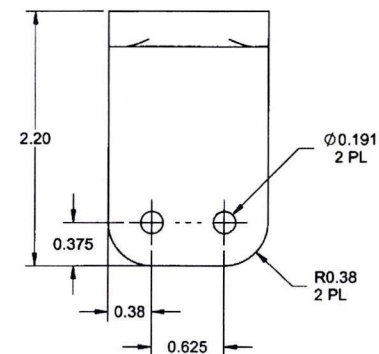
ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A



D3910-1 X-TUBE LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **193736 MLS**
19-04-22



RELEASED
2014 JUN 05

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3910	REV. E
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
DATE	14.05.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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Container No: S174440



Part: D3910-1

Job No: 193736

Serial No/Batch: S174440

Revision: E

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/23/19